

Date: Friday, 13/06/2008 10:46:29 AM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HIGH AFT X-TUBE 412			
Job Number	: 39854			Part Number	: D412664203		
Estimate Number	: 10559			Drawing Number	: D412-664-243 REV D		
P.O. Number	:			Project Number	: N/A		
This Issue	: 13/06/2008	S.O. No. :		Drawing Revision	: D		
Prsht Rev.	: NC			Material	:		
First Issue	: / /		Type : CROSSTUBES	Due Date	: 20/06/2008		
Previous Run	: 39580			Qty:	1 Um: Each		
Written By	:						
Checked & Approved By	: <u>JUL 08 10-13</u>						
Comment	<p>Est Rev:E 04.02.16 Rerformat; Added D3189-1 K/DS</p> <p>Est Rev:F 06-03-29 Remove Coments on Pick List JLM</p> <p>Est Rev:G 06.12.08 per ECN 886 EC</p> <p>Est Rev:H 07-04-30 As per Rev D JLM</p> <p>Est Rev:I 08-06-12 add comment in seq. 21 DD verified by:EC</p>						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
		 Comment: DOCUMENT CONTROL Photocopy bluefile and create labels as per PPP D412-664-203 CHG 006
2.0	PACKAGING 1	PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1
3.0	D412664203TRN	Crosstube Turning Detail Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) CROSSTUBE TURNING DETAIL batch <u>B39684</u>
4.0	BENDING	BENDING MACHINE - SKIDTUBES Comment: BENDING MACHINE Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010
5.0	QC15	DIMENSIONAL CHECK OF X-TUBES Comment: DIMENSIONAL CHECK OF X-TUBES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-664-203 PAR #: _____ Fault Category: cross tubes NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR: 39854		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.06.27	4	ONE SIDE CENTER BIENT @ 53.56	CP 08.06.27 pc QSI 042	PART ACCEPTABLE	DP 8/2/1	J 680701	CP 08.06.27 pc QSI 042	/

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: HIGH AFT X-TUBE 412
Job Number: 39854		Part Number: D412664203
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	CROSSTUBES	CROSSTUBES RESOURCE 1 
Comment: LANDING GEAR RESOURCE 1 1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551. 2-Ream hole to finish size in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes. 3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243		
<i>Awm 8-7-1</i>		
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
<i>Awm 8-7-1</i>		
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
<i>08/07/01 (40)</i>		
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
9.0	QC5	INSPECT WORK TO CURRENT STEP 
<i>08/07/01 (40)</i>		
Comment: INSPECT WORK TO CURRENT STEP		
10.0	OUTSIDE SERV.10	OUTSIDE SERVICES -skids 
<i>08/07/01 (40)</i>		
Comment: Sub-Contracting OUTSIDE SERVICES Liquid Penetrant Inspection as per QSI 0380 or Issue P/O: <u>6687</u> LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order		
11.0	PACKAGING 1	PACKAGING RESOURCE #1 
<i>08/07/040</i>		
Comment: PACKAGING RESOURCE #1 Inspect for transit damage Ensure copy of NDT results attached to work order.		
<i>Pd/13 6</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 39854

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



ML 08 07 03



(1)

Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

13.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

ML 08 07 04

(1)

2-Paint outside crosstube with White Imron as per QSI 005 4.2

ML 08 07 07

(1)

14.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

ZT 08-07-08

PIC

15.0

D3595063570

RUBBER CUSHION



2



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rubber Cushion

Batch: 35126

ZT 08-07-09

16.0

D2856600

Abrasion Strip



Comment: Qty.: 1.7640 f(s)/Unit Total : 1.7640 f(s)

Pick:

Qty Part number Description Batch

2 D2856-600(Cut to 10.090") Abrasion Strip 36398

ZT 08-07-09

17.0

D28961

Support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2896-1 Support 33471

ZT 08-07-09

18.0

D31891

Chafing Shield



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D3189-1 Chafing Shield 37884

ZT 08-07-09

W/O: 39854	Est# 10559	WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08-07-05	15.0	Qty 2 only required. Perm. Change				08-07-05	08-07-05

Part No: 0412-664-203 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 13/06/2008 10:46:29 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: HIGH AFT X-TUBE 412
Job Number: 39854		Part Number: D412664203
Job Number:		
Seq. #:	Machine Or Operation:	Description :
19.0	MS2192028	Clamp(per MIL-DTL-8783C)
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)		
Pick: Qty Part number Description Batch 4 MS21920-28 Clamp <u>107502</u>		2T 08-07-09
20.0	MS2192030	clamp(per MIL-DTL-8783C)
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) clamp(per MIL-DTL-8783C) batch: <u>106810</u>		2T 08-07-09
21.0	CROSSTUBES	CROSSTUBES RESOURCE 1
Comment: LANDING GEAR RESOURCE 1 Assemble as per Dwg D412-664-203		
1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe		
2-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs A/R 6398 Magnobond Batch: <u>107621</u> Expiry Date: <u>08-09-17</u>		2T 08-07-09
3-Install clamps as per Dwg D212-664-203 using installaiton jig DT9024 with 0.010 thick brass shims on both chafing shield (D3189-1). Torque clamps to 80-100 in lb.		
22.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		 S 08/07/10 (eo)
23.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Pick Packing Kit		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 13/06/2008 10:46:29 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 39854

Part Number: D412664203

Job Number:



Seq. #: Machine Or Operation:

Description :

24.0 AN640A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M107376

25.0 AN641A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M107013

26.0 AN960JD616 Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch: M107959

27.0 MS21042L6 Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: M108070

28.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

29.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-664-203

*****Ensure tube is not packaged if curing time is less than 12 hrs, see step 27 for application time & date

Time & date of packaging: 12:30 pm 08/07/10

Location: Rev G

PPP Rev: 1808/07/06

39854 0412-664-203

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 39854

Part Number: D412664203

Job Number:



Seq. #:	Machine Or Operation:	Description :
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30.0	QC21	FINAL INSPECTION/W/O RELEASE
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08/07/10 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

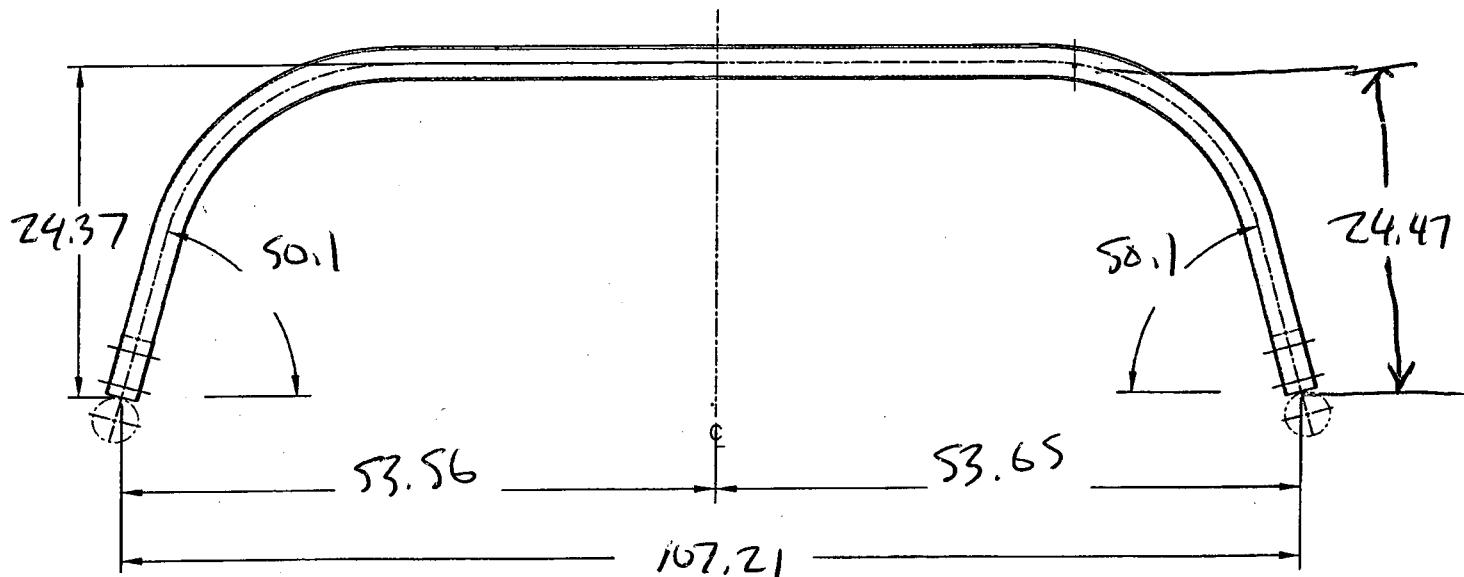
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39854
Description: Crosstube High Aft (412)	Part Number:	D412-664-203
Inspection Dwg: D412-664-243 Rev: D		Page 1 of 1

Required Dimension	Min	Max
Height	24.24	24.50
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70



Comments
PART ACCEPTABLE

QC15 Inspection	CP
Date	06.06.27

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.08	Dimensions updated per Dwg rev. D	KJ/JLM	JM

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>GP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D412-664-243	REV. D SHEET 1 OF 3
DATE 07.03.09		TITLE CROSSTUBE ASSEMBLY (412 HI AFT)	SCALE NTS
A	01.10.17	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	06.10.27	REMOVE D2856-600-1087, ADD D2732-058 & MAGNOBOND 6398 MS21920-32 WAS MS21920-30	
D	07.03.09	REMOVE D2732-058, CHANGE TO D3595-063-570	

RELEASED

07.04.24 *[Signature]*

Qty	Part Number	Description
X	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
1	D6009-129	CROSSTUBE
2	D3595-063-570	RUBBER CUSHION
1	D2896-1	SUPPORT
2	D2856-600-1009	ABRASION STRIP
4	MS21920-28	CLAMP
2	MS21920-30	CLAMP (OR MS21920-32)
2	D3189-1	CHAFING SHIELD
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

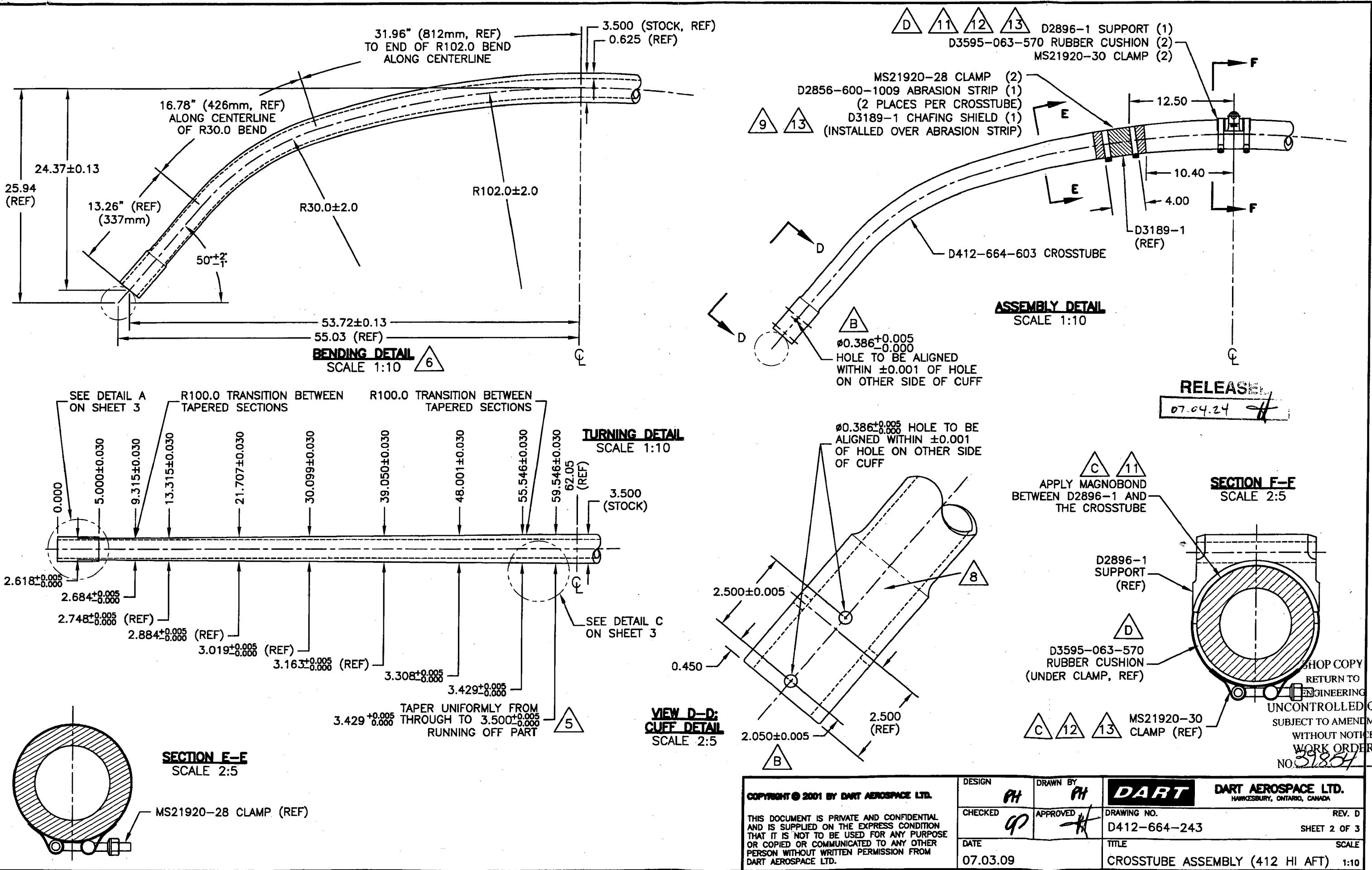
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6009-129
FINISHED LENGTH = 124.09 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

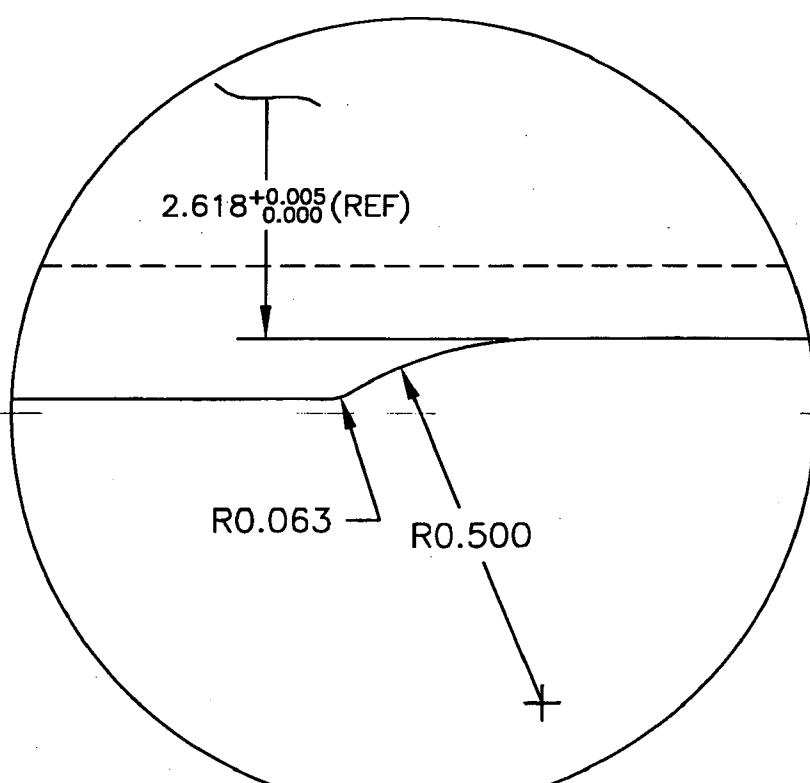
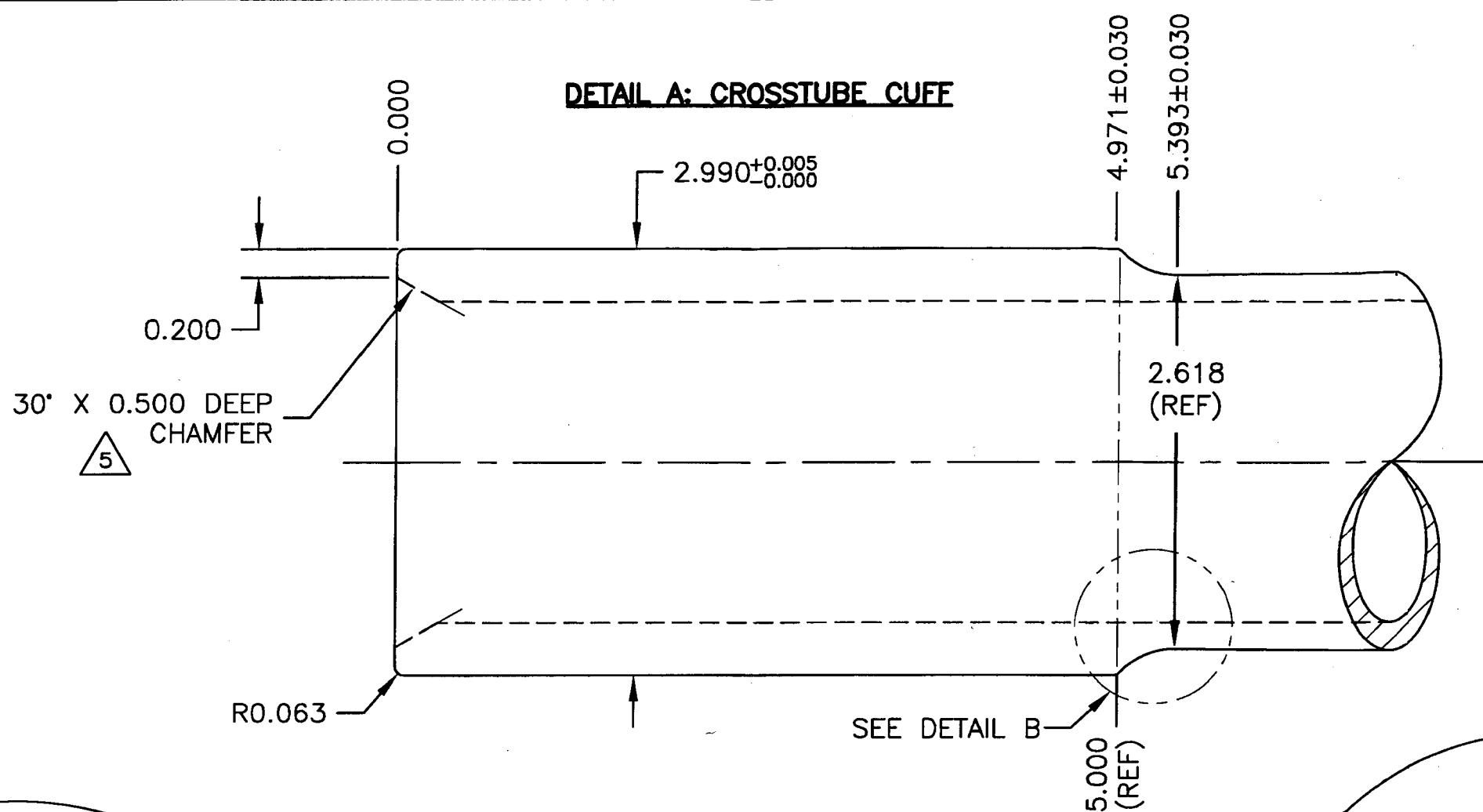
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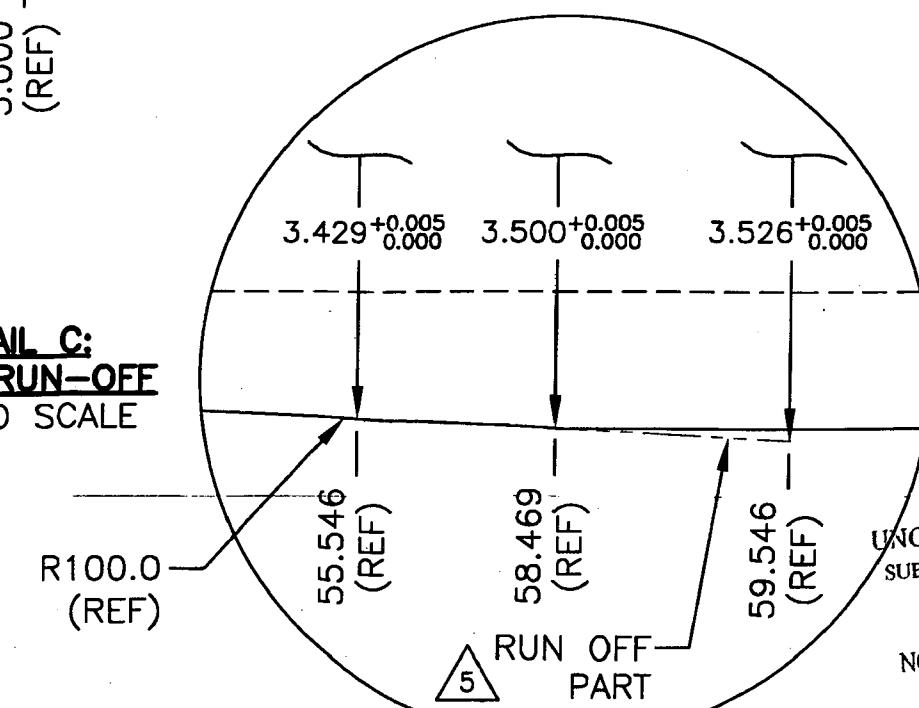
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RELEASED
07.04.244P
PER ECN 899



**DETAIL C:
TAPER RUN-OFF**
NOT TO SCALE

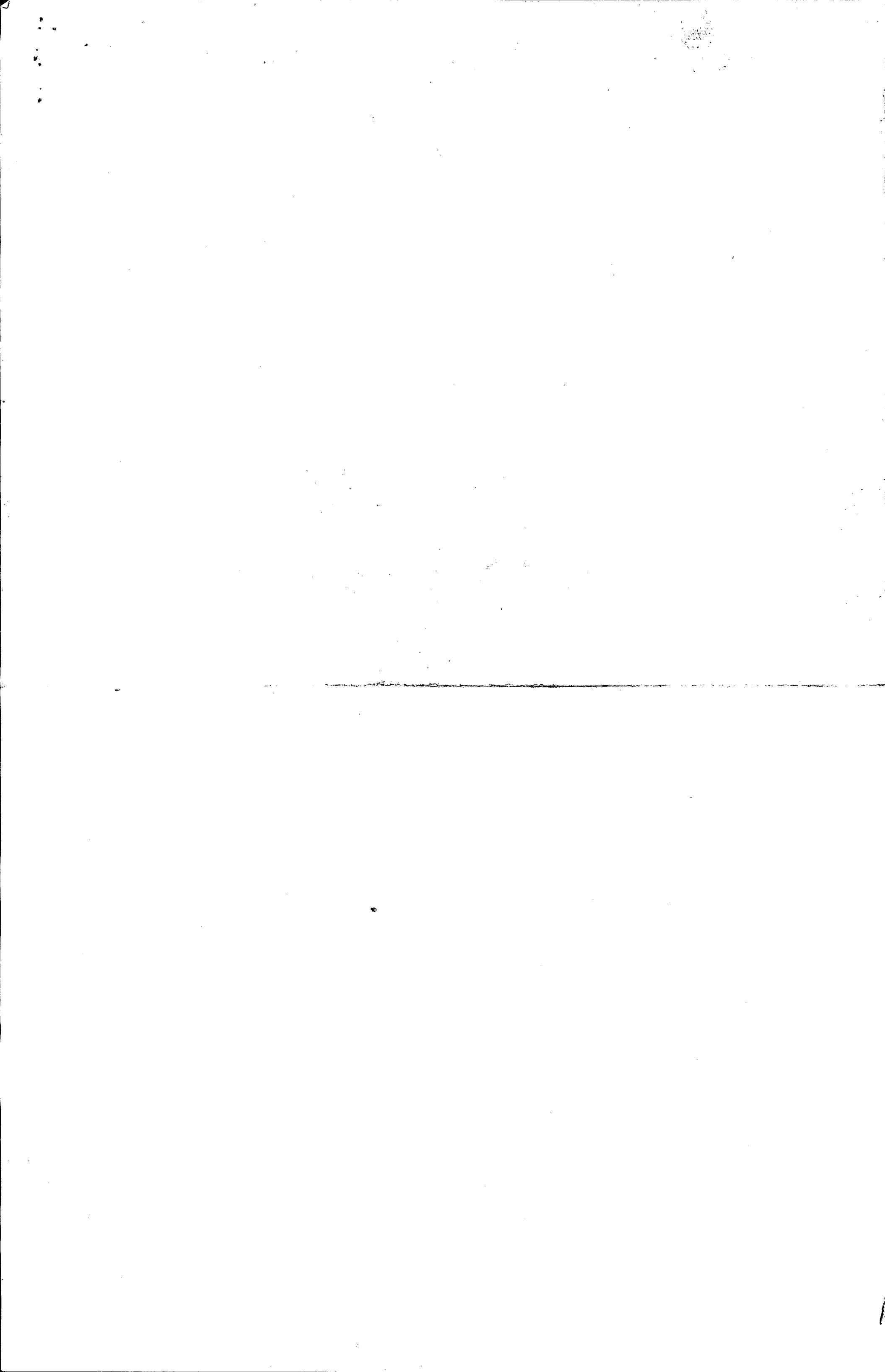


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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
PH	PH		REV. D
CHECKED	APPROVED		DRAWING NO.
			D412-664-243
DATE			SHEET 3 OF 3
07.03.09			SCALE
			1:1
			CROSSTUBE ASSEMBLY (412 HI AFT)





LIQUID PENETRANT TEST REPORT

P - 1380 1

ACUREN

CLIENT	DART AEROSPACE	DATE	JULY 3, 2008	PAGE	1	OF 1
ATTENTION	LINDA LACELLE	ACUREN JOB NO.	188 08 1380	TIME	AM <input type="checkbox"/>	PM <input type="checkbox"/>
ADDRESS	1270 ABERDEEN ST	PO/WO NO.	66 89			
	HAWKESBURY, ONT.	WORK LOCATION	HAWKESBURY			
PROJECT	212/205 HIGH FED X TUBES, 407 FWD X TUBES, 412 HIGH AFT X TUBES	ACCEPTANCE STD.	ASTM 1417/QSI-038	REV./DATE	2005	
ITEM(S) EXAMINED	JOB #'S 39905, 39906, 39365, 39366, 39854, 39855.					

JOB DESCRIPTION	PROCEDURE NO.	LT-0002 REV./DATE	TECHNIQUE NO.	LT-TECH2	REV./DATE
'PART NO. D212664101/D407667105/D412664203.		MATERIAL	ALODINED ALUM.	THICKNESS	
SCOPE	WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% EXTERNAL SURFACE				

TEST DETAILS						
METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED	
FAMILY BRAND	MAGNAFLUX		BLACK LGHT8171	<input type="checkbox"/> OUTPUT > 1000 μ W/cm ²	<input type="checkbox"/> AMBIENT < 2 fc	
PENETRANT ZL67	MINIMUM DWELL TIME	45 MIN.	LIGHTING EQUIP.	<input type="checkbox"/> FLASHLIGHT	<input type="checkbox"/> TROUBLELIGHT	<input type="checkbox"/> OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER H ₂ O	MINIMUM DRY TIME	>10 MIN.	OTHER	CAL MAY 108		
DEVELOPER SKDS2	MINIMUM DWELL TIME	10 MIN.	LIGHT METER S/N	CAL DUE DATE		
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY			
TEST SURFACE						
SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input checked="" type="checkbox"/> CLEAN BARE METAL	
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/20°F	<input type="checkbox"/> -4°C/20°F TO 10°C/50°F		<input type="checkbox"/> 10°C/50°F TO 52°C/125°F	<input type="checkbox"/> > 52°C/125°F	
RESULTS-	<input type="checkbox"/> METRIC <input checked="" type="checkbox"/> IMPERIAL)					

FLUORESCENT LIQUID PENETRANT INSPECTION

CARRIED OUT ON 100% EXTERNAL

SURFACE ON:

212/205 HIGH FED X TUBES JOB #'S 39905, 39906

407 FWD X TUBE JOB #'S 39365, 39366.

412 HIGH AFT X TUBE JOB #'S 39854, 39855.

ml 08 07 03

RESULTS: NO INDICATION OF DEFECTS.

ITEMS ACCEPTABLE TO STANDARD

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE			SIGNATURE	DTR # E 19904	
TECHNICIAN (SIGNATURE):				REPORT	REVIEWED BY:
NAME (PRINT):	JASON HEWETT 1 ST TECHNICIAN		2 ND TECHNICIAN	NAME INITIALS	
	CGSB LEVEL	2	SNT LEVEL	CGSB LEVEL	SNT LEVEL
	CGSB REG. NO.	6156		CGSB REG. NO.	

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